

Atty's 21543

Pat. App. 09/603,528

CLAIM AMENDMENT

1 1. (currently amended) A method of making a sample tube
2 ~~especially to receive a biological sample~~, comprising the steps of:
3 injection molding an intermediate tube in one piece with
4 a cylindrical wall and ~~an~~ a conical intermediate bottom spaced
5 between ends thereof, integral with said wall and having an apex
6 turned toward an end of said intermediate tube thereby forming a
7 well adapted to receive a biological sample; and

8 heating said an end of said intermediate tube and press-
9 ing edges of said end inwardly toward an axis of said intermediate
10 tube to thermally reform said tube and provide at least a partial
11 bottom end for the sample tube; and

12 rounding the bottom end of the sample tube outside an
13 injection mold in which said tube is formed by pressing a heated
14 stamp thereagainst to cause said bottom end of said sample tube to
15 be shaped to a concavity of a concave recess of said stamp and to
16 be only partially closed by said stamp whereby said bottom end is
17 self-orienting upon insertion of the sample tube into a stand to
18 permit removal of the biological sample from said well by a pi-
19 pette.

2. - 4. (canceled)

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1 5. (currently amended) The method defined in claim 4 1
2 wherein said stamp heats said intermediate tube to a temperature at
3 least equal to the flow temperature of a thermoplastic synthetic
4 resin constituting said intermediate tube.

6. - 9. (canceled)